

Page 1

MAY 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																												
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																												
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																												
Large Fab ☐	Composite ☐	Supplier ☐																																																																													
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																											
Description Work Order Deviation			Disposition																																																																												
			Completed By																																																																												
			Lead hand / Supervisor Approval Verification																																																																												
			QC / QA Coordinator Approval																																																																												
<table style="width:100%; border: none;"> <tr> <td colspan="3" style="text-align: center;">Root Cause</td> <td colspan="3" style="text-align: center;">FAULT CATEGORY</td> </tr> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">☐ No Re-verification</td> <td style="border: none;">☐ Pressure/Forced</td> <td style="border: none;">☐ Temperature/Cure</td> <td style="border: none;">☐ Power Loss/Surge</td> <td style="border: none;">☐ Positioned Wrong</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">☐ Operator</td> <td style="border: none;">☐ Bending</td> <td style="border: none;">☐ Set-up</td> <td style="border: none;">☐ Folio/Program</td> <td style="border: none;">☐ Outside Dimensions</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">☐ Offset/Setup</td> <td style="border: none;">☐ Centre Not Concentric</td> <td style="border: none;">☐ BOM/Route</td> <td style="border: none;">☐ Grain</td> <td style="border: none;">☐ Over/Under tolerance</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">☐ Supplier</td> <td style="border: none;">☐ Cracks</td> <td style="border: none;">☐ Broken/Damage/Defect</td> <td style="border: none;">☐ Weld</td> <td style="border: none;">☐ Part Incorrect</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">☐ Training</td> <td style="border: none;">☐ Crimp/Kink/Ripple/Wave</td> <td style="border: none;">☐ Inspection Incomplete/Unqualified</td> <td style="border: none;">☐ Wrong Stock Pulled</td> <td style="border: none;">☐ Part Lost/Missing</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">☐ Use for Testing</td> <td style="border: none;">☐ Cuffs</td> <td style="border: none;">☐ Contamination</td> <td style="border: none;">☐ Out of Sequence</td> <td style="border: none;">☐ Part Moved</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">☐ Poor Information</td> <td style="border: none;">☐ Crushing</td> <td style="border: none;">☐ Countersink</td> <td style="border: none;">☐ Off-set</td> <td style="border: none;">☐ Drawing</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">☐ Rushing</td> <td style="border: none;">☐ Heat Treat</td> <td style="border: none;">☐ Cut Too Short</td> <td style="border: none;">☐ Mislabeled</td> <td style="border: none;">☐ Finish</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">☐ Product Improvement</td> <td style="border: none;">☐ Wave/Twist in Tube</td> <td style="border: none;">☐ Instructions Incomplete/Unclear</td> <td style="border: none;">☐ Fit/Function</td> <td style="border: none;">☐ Misread</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">☐ Process Improvement</td> <td style="border: none;">☐ Marks/Chatter</td> <td style="border: none;">☐ Drill Holes</td> <td style="border: none;">☐ Misaligned/off center</td> <td style="border: none;">☐ Turning Sequence</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">☐ Manufacturing Process</td> <td colspan="4" rowspan="2" style="vertical-align: top;">OTHER : _____</td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">☐ Past Due</td> </tr> </table>						Root Cause			FAULT CATEGORY			Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____				Misidentified ☐	☐ Past Due
Root Cause			FAULT CATEGORY																																																																												
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong																																																																										
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions																																																																										
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance																																																																										
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect																																																																										
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing																																																																										
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved																																																																										
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing																																																																										
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish																																																																										
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread																																																																										
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence																																																																										
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____																																																																													
Misidentified ☐	☐ Past Due																																																																														

Work Order ID 144728

Friday, April 22, 2016 3:25:30 PM

144728

Page 2

Item ID: D145-762-153

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Run-on Landing Wearplates for Standard Skid tubes, Fit LH or RH

Start Date: 5/9/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/12/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D145-762-153 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

PPP 144724

SMB

16/5/19

16/5/25

4ME
16-5-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, April 22, 2016 3:25:37 PM

Page 1

Work Order ID: 144728

144728

Parent Item: D145-762-153

D145-762-153

Parent Item Name: Replacement Run-on Landing Wearplates for Standard Skid tubes, Fit LH or RH

Start Date: 5/9/2016

Required Date: 5/12/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.24 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.14 AS PER IIN REV.C DD VERF:JLM IPP REV:C
14.11.24 as per ecn14-654/chg003 DD VERF:JLM IPP REV:D 15.06.11 IIN
REV.D DD VERF:JLM IPP REV:E 16.02.05 IIN REV.E
(ecn16-514) DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C43A		Purchased	No				Each	100.0000		4			
AN4C43A									**				DAS 27 9-89
BOLT													DAS 6 9-89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST341			100						
				m132070			100						
D4769-041		Manufactured	No			110	Each	6.0000	1	1			
D4769-041									**				DAS 27 9-89
Wearplate Assembly												MAY 05 2016	DAS 6 9-89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				FP001			6						
				133489			3						
				139036			3						
D4773-041		Manufactured	No			110	Each	0.0000	1	1			
D4773-041									**				DAS 27 9-89
Wearplate Assembly													
D4771-041		Manufactured	No			110	Each	0.0000	1	1			
D4771-041									**				DAS 27 9-89
Wearplate Assembly												MAY 16 2016	DAS 6 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

Friday, April 22, 2016 3:25:37 PM

Page 2

Work Order ID: 144728

144728

Parent Item: D145-762-153

D145-762-153

Parent Item Name: Replacement Run-on Landing Wearplates for Standard Skid tubes, Fit LH or RH

Start Date: 5/9/2016

Required Date: 5/12/2016

Start Qty: 1.00

Required Qty: 1.00

D4764-1 Manufactured No 110 Each 74.0000 12 12

D4764-1

Bushing

DAS 27
6 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST124

74

128558

4

132495

70

12

AN4C42A Purchased No

AN4C42A

Bolt

DAS 27
6 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST341

38

M131947

38

2

MS21043-4 Purchased No

MS21043-4

Nut

DAS 27
6 9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

103

m132803

103

OVER007

300

m134502

300

ST302

471

m133769

171

m134249

300

DAS
28
9-89

MAY 09 2016

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
OTHER :									

Work Order ID 144728

144728

Page 1

Friday, April 22, 2016 3:25:30 PM

Item ID: D145-762-153 Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: Replacement Run-on Landing Wearplates for Standard Skidtubes, Fit LH or RH Stop *NS2*

Start Date: 5/9/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/12/2016 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: *Jim* Date: *16/04/22* Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-762	E	MAY 05 2016							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D145-762-153 CHG004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAY 05 2016

MAY 05 2016